

514

Spht

DART AEROSPACE LTD		Work Order:	23354 <i>BS</i>
Description: Maintenance Step, FH		Part Number:	D3436-044/-041
Dwg: D3436 Rev. A		Qty:	10 <i>2</i>
		Page 1 of 1	

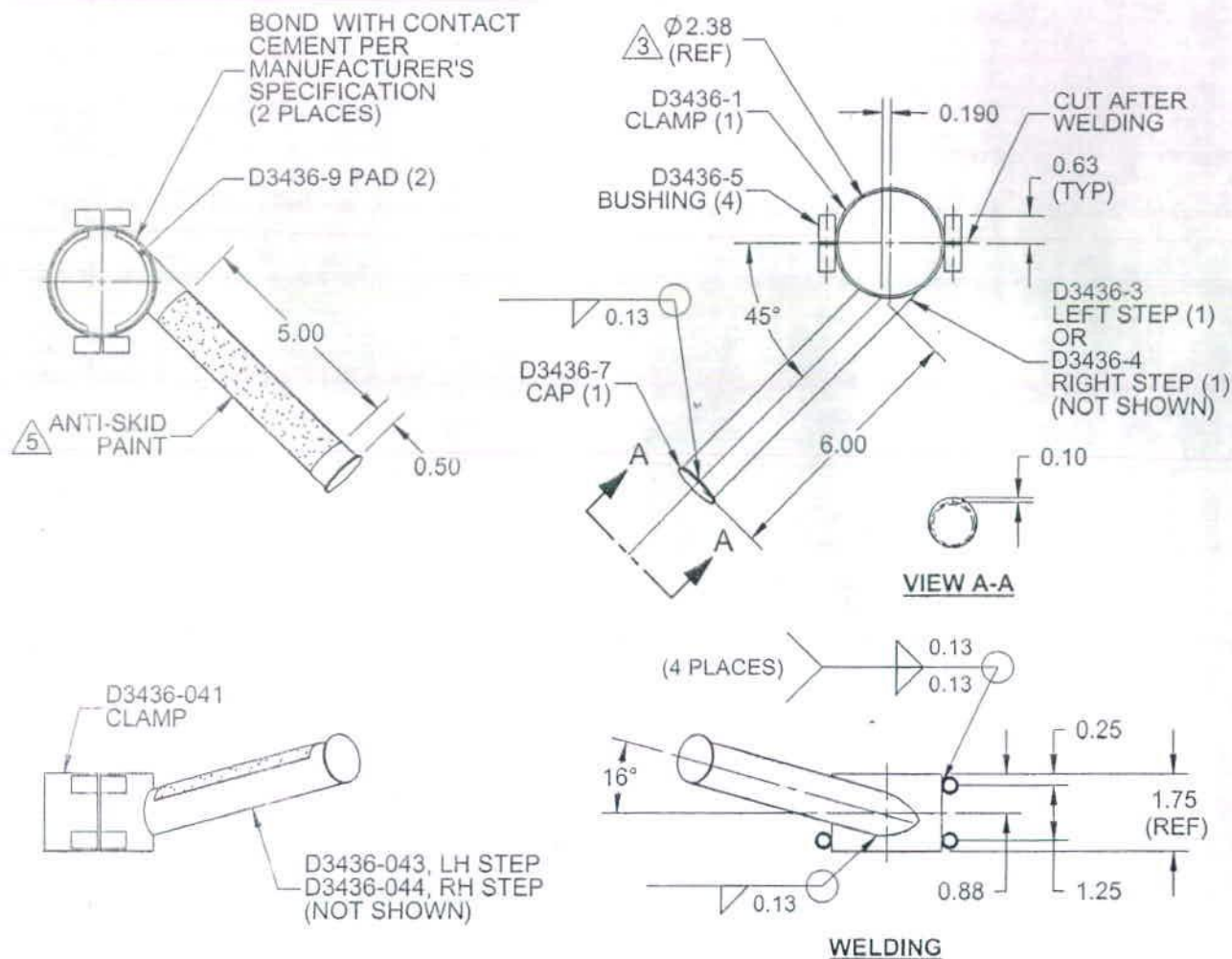
Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler	KJ	05.06.09	10																				
2	WS	Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3436-1</td><td>Clamp</td><td>M17679</td></tr><tr><td>1</td><td>D3436-4</td><td>LH Step</td><td>M17669</td></tr><tr><td>4</td><td>D3436-5</td><td>Bushing</td><td>31557</td></tr><tr><td>1</td><td>D3436-7</td><td>Cap</td><td>B23358</td></tr></table>	Qty	Part Number	Description	Batch	1	D3436-1	Clamp	M17679	1	D3436-4	LH Step	M17669	4	D3436-5	Bushing	31557	1	D3436-7	Cap	B23358	CPL	05.08.04	10
Qty	Part Number	Description	Batch																						
1	D3436-1	Clamp	M17679																						
1	D3436-4	LH Step	M17669																						
4	D3436-5	Bushing	31557																						
1	D3436-7	Cap	B23358																						
3	WS	Weld bushings and clamp using welding Jig DT8772 and Dwg D3436 <i>to D3436-5 deviation can use 6.063 wall and ensure butt fit.</i> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>A/R</td><td>N/A</td><td>4130 Welding Rod</td><td>M9430</td></tr></table> Dwg Rev: A	Qty	Part Number	Description	Batch	A/R	N/A	4130 Welding Rod	M9430	CPL	05.08.04	10												
Qty	Part Number	Description	Batch																						
A/R	N/A	4130 Welding Rod	M9430																						
4	WS	Weld left step using welding Jig DT8773 and Dwg D3436 <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>A/R</td><td>N/A</td><td>4130 Welding Rod</td><td>M9430</td></tr></table> Dwg Rev: A	Qty	Part Number	Description	Batch	A/R	N/A	4130 Welding Rod	M9430	CPL	05.08.04	10												
Qty	Part Number	Description	Batch																						
A/R	N/A	4130 Welding Rod	M9430																						
5	WS	Weld cap as per Dwg D3436 <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>A/R</td><td>N/A</td><td>4130 Welding Rod</td><td>M9430</td></tr></table> Dwg Rev: A	Qty	Part Number	Description	Batch	A/R	N/A	4130 Welding Rod	M9430	CPL	05.08.04	10												
Qty	Part Number	Description	Batch																						
A/R	N/A	4130 Welding Rod	M9430																						
6	WS	Slit part on bandsaw as per Dwg D3436 Identify as D3436-044 & -041 Dwg Rev: A	CPL	05.08.04	10																				
7	QC9	Inspect welds and work to Step 6	2	05.06.19	10																				
8	GA	Deburr	CPL	05.08.11	10																				
9	FP	Powder Coat Gloss White (Ref: 4.3.5.2) as per QSI 005 4.3	FC	05.09.04	10																				
10	FP	Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4	FC	05.09.12	10																				
11	QC3	Inspect Powder Coat	NA	05.09.13	10																				
12	GA	Install pad using contact cement as per manufacturer's instructions and Dwg D3436 Dwg Rev: A Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D3436-9</td><td>Pad</td><td>B20359</td></tr><tr><td>A/R</td><td>N/A</td><td>Contact Cement</td><td>M16 R4</td></tr></table>	Qty	Part Number	Description	Batch	2	D3436-9	Pad	B20359	A/R	N/A	Contact Cement	M16 R4	SB	05/09/15	2								
Qty	Part Number	Description	Batch																						
2	D3436-9	Pad	B20359																						
A/R	N/A	Contact Cement	M16 R4																						
13	QC5	Inspect work to Step 12	2	05.05.15	1																				
14	ST	Identify and Stock	CZ	05/09/15	1																				
15	AC	Cost / part: 44.28 21.77	S	05.08.15	1																				
16	DC	Close W/O 44.28 25.02 Inspect Level 21	DP	05/09/15	1																				

Rev	Date	Change	Revised By	Approved
A	05.05.11	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED
2/05/16



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:4
A	05.04.28	NEW ISSUE	



NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27
RETURN TO
ENGINEERING

23354

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